

Date: Thursday, 27/11/2008 3:06:03 PM
User: Linda Lacelle

H SAP

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : STEM

Job Number : 43834

Estimate Number : 10857

P.O. Number :

This Issue : 27/11/2008 S.O. No. :

Prsht Rev. : NC

First Issue : / /

Type : MACHINED PARTS

Previous Run : 42439

Part Number : D34077

Drawing Number : D3407 REV E

Project Number : N/A

Drawing Revision :

Material :

Due Date : 04/12/2008

Qty:

30 Split 2

Um: Eac

Written By :

Checked & Approved By :

Comment :

Est Rev:A 05-10-18 New issue KJ/EC

Est Rev:B Now on Doosan 08-05-14 JLM Verified By:DD

Est Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M174R0750

17-4 round bar .750



Comment: Qty.: 0.3843 f(s)/Unit Total: 3.8430 f(s)

Material: 17-4ph SS Round Bar Ø0.750(M17-4-R0.750)

Identify for D3407-7

Batch: M109478

SA 08/12/03

2.0

DOOSAN LATHE

DOOSAN LATHE



Comment: DOOSAN CNC LATHE

1-Turn as per Folio FA N/A Rev: N/A & Dwg D3407 Rev: E

2-Deburr

SA 08/12/03

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 08/12/03

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08-12-03 (2)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

W 43685

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEM

Job Number: 43834

Part Number: D34077

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/05 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.12.05

DART AEROSPACE LTD

Work Order: 43834

Description: Stem

Part Number: 3407-7

Inspection Dwg: Rev: E

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
063	+ .010	063	/			
1/428 UNF	Max. .2668 Min. .2635	.2655	/			
Major Ø	Max. .249 Min. .2425	.246	/			
Ø .625	± .010 +.006 - .001	Ø .626	/			
Ø .750	± .010 +.006 - .001	.751	/			
.150	+ .010	.150	/			
.550	+ .010	.551	/			
.500	+ .010	.500	/			
3.500	+ .010	3.500	/			
4.500	+ .000 - .010	4.500	/			
5.700	+ .010	5.400	/			
.500	+ .000 - .010	.495	/			
.350	+ .010	.351	/			
.625	+ .010	.626	/			
.250	+ .010 - .000	.252	/			

Measured by: SA
Date: 08/12/03

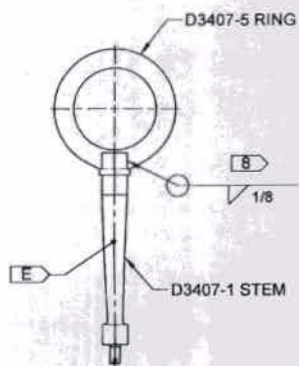
Audited by: [Signature]
Date: 08-12-03

Prototype Approval: N/A
Date: N/A

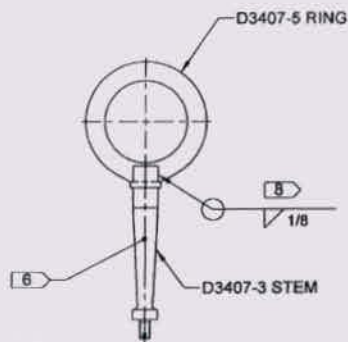
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

[Signature]

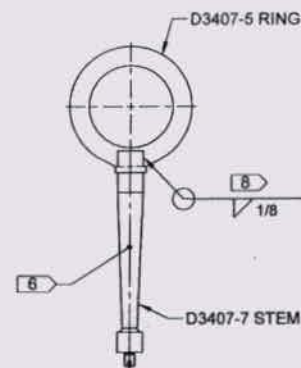
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM



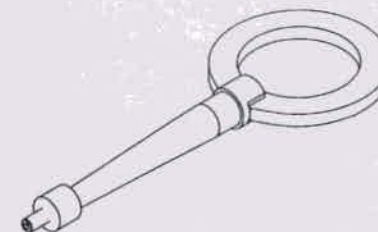
D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING

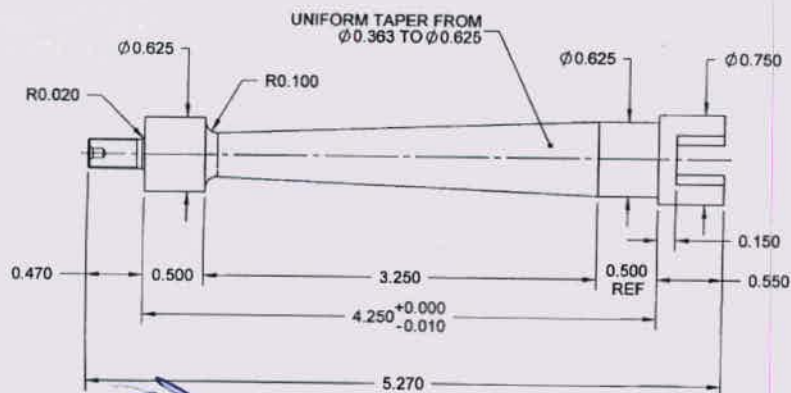
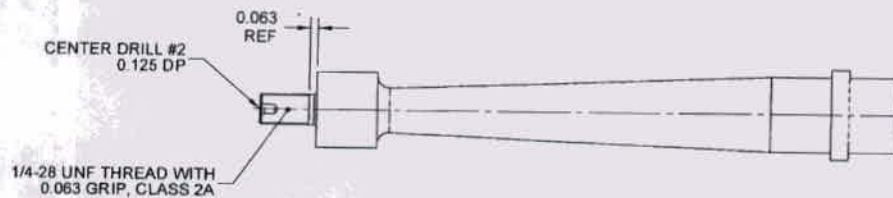


RELEASED

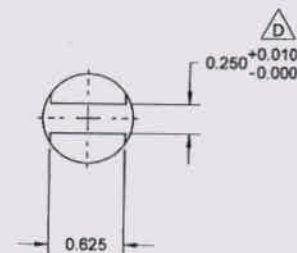
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE USA, INC.		
DRAWN	PORT HADLOCK, WA		
CHECKED	DRAWING NO.	REV. E	
MFG. APPR.	D3407	SHEET 1 OF 5	
APPROVED	TITLE	SCALE	
DE APPR.	TOW RING	NTS	
DATE	08.07.23	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3407-1 STEM



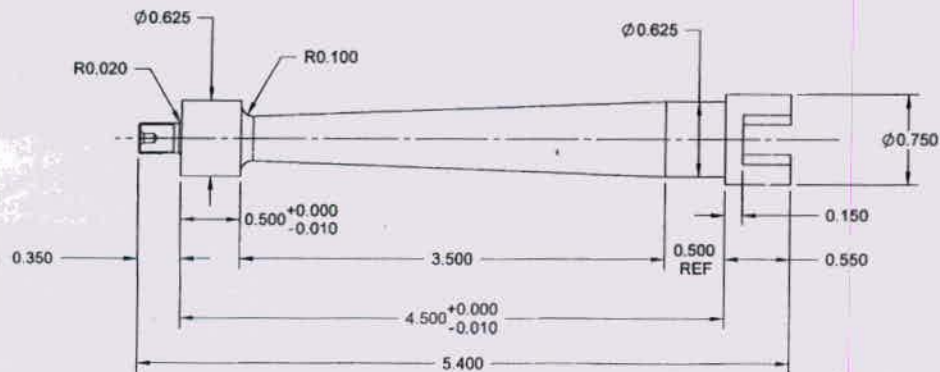
- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.33 lbs

RELEASED

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	<i>HP</i>	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.	<i>Jeff</i>	D3407	SHEET 2 OF 5
APPROVED	<i>Jeff</i>	TITLE	SCALE
DE APPR.	<i>HP</i>	TOW RING	NTS
DATE	08.07.23	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHEN SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

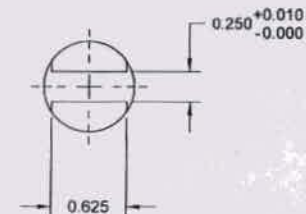
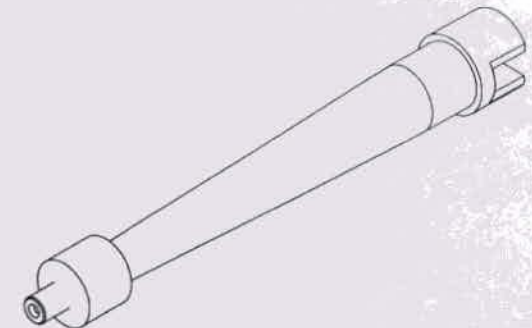
0.063
REF
CENTER DRILL #2
0.125 DP

1/4-28 UNF THREAD WITH
0.063 GRIP, CLASS 2A



D3407-7 STEM

W/ 43834



- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs

RELEASED

DESIGN	AJS	DART AEROSPACE USA, INC.	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED		DRAWING NO	REV. E
MFG. APPR		D3407	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.07.23	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR EXPOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

